

Work Order ID 83324

83324

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Tuesday, April 17, 2012 1:16:50 PM

Item ID: D2877 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle Spacer
 Start Date: 4/17/2012 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 4/25/2012 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: Date: 12-04-17 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2877	Rev B

100 FLOW WATER JET 0.00
100 0.00
 Waterjet Memo
 FLOW CNC Waterjet 1-Cut as per Dwg D2877 Dwg Rev: B Prog Rev: B 2-
 6061.128 deburr
 HB 12-4-22 (46)

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110 0.00
 QC Memo
 Quality Control HB 12-4-22

120 QC8- Inspect parts - second check 0.00
120 0.00
 QC Memo
 Quality Control S. 2/14/12 (48)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary								
140		0.00							
140	Chemical Conversion Coat per QSI005 4.1								
HandFinish	Memo	0.00							
Hand Finishing									
150		0.00							
150	QC3- Inspect Part Finish								
QC	Memo	0.00							
Quality Control									

(40) 2/6 12-4-23

H0 d 12/4-23

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Picklist Print

Tuesday, April 17, 2012 1:16:54 PM

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Parent Item: D2877

D2877

Parent Item Name: Saddle Spacer

Start Date: 4/17/2012

Required Date: 4/25/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP B 00.05.19 Added inspect level 8EC
 IPP C 06.04.26 Water jet EC
 IPP Rev:D Now M6061-T6 06-06-23 JLM
 IPP Rev:E Updated Thickness as per Rev B 06-09-18 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			110	sf	61.2900	0.0607	2.555789			

M6061T6S 125

6061-T6 .125 Sheet

**

B12-4-22

Location

Loc Qty

Loc Code

MAT021

61.29

121437

113608

46.69

118217

0.09

119513

10.8

120218

3.71

(40)

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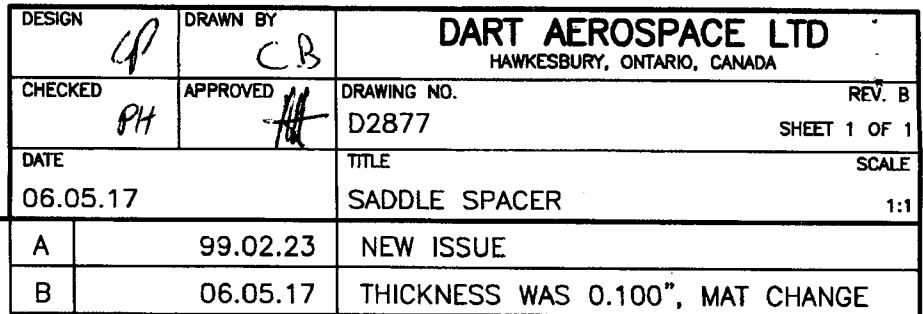
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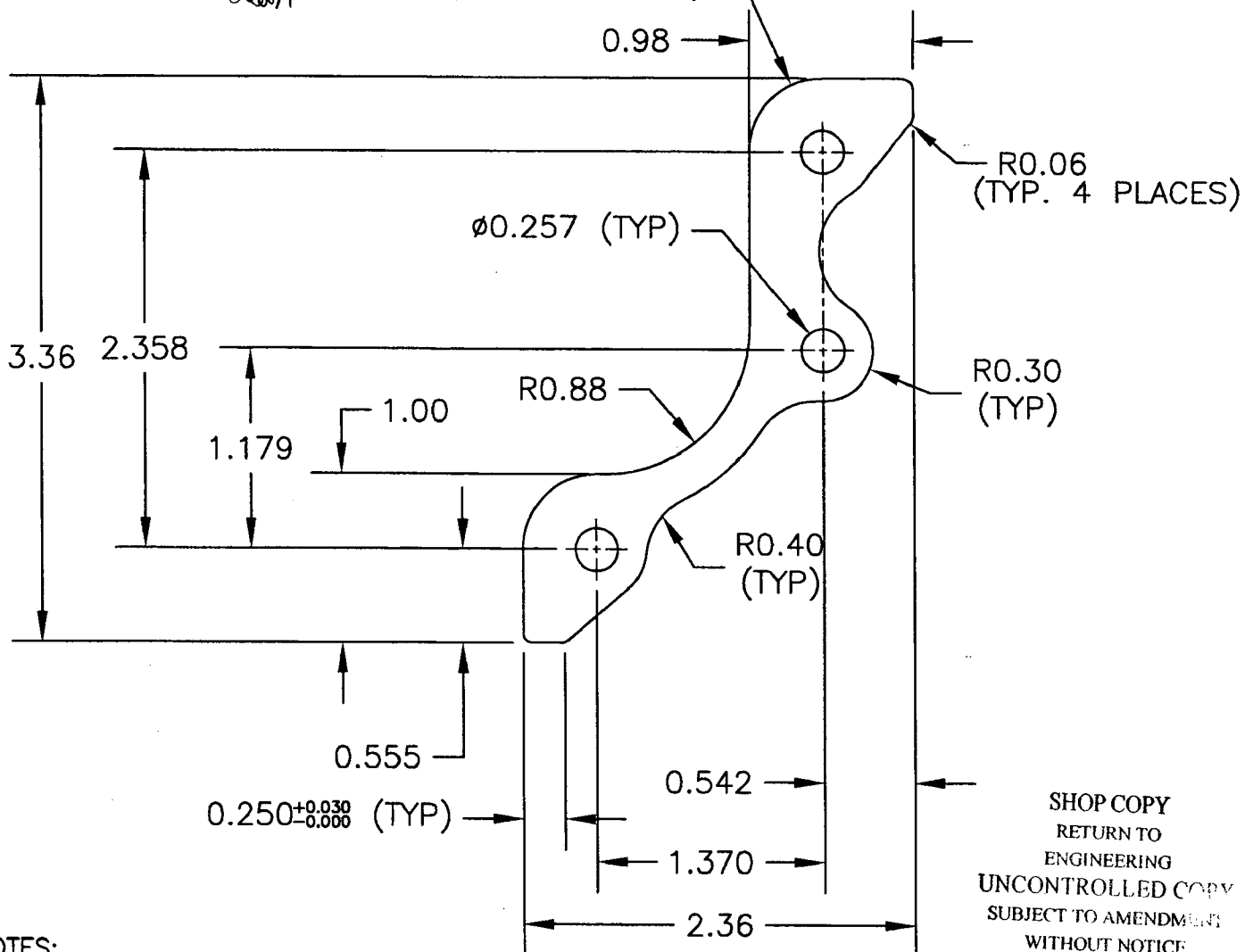
•NOTE: Date & initial all entries



RELEASED
06-06-21

AS PER ECN 813
Sh

R0.44 (TYP 2 PLACES)



1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.125" THICK
(REF DART SPEC M6061T6S.125)
OR
5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.125" THICK
(REF DART SPEC M5052H32S.125)

2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) BREAK ALL SHARP EDGES 0.010 TO 0.020

5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENTS
WITHOUT NOTICE
WORK ORDER
NO. 88314

012-04-11

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